

Work Order ID/ 56882

March 12, 2010 10:01:01 AM

Page 1

Item ID: D2807-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door prop

Start Date: 3/12/10 Start Qty: 24.00

Required Date: 3/19/10 Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: 10/3/12 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2807

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *11504* Order as per Dwg D2807. Possible
supplier: Lift Support Technologies, Saskatoon, Canada! IP/N 6/15-164/50-115N

Material release note is required

CL 10/3/12 24

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

10/3/16 (24)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

*8/10/07/16**certs*
*(24)**5 tests Q 29/165 to 29.5/165.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56882

March 12, 2010 10:01:02 AM

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Item ID: D2807-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door prop

Start Date: 3/12/10 Start Qty: 24.00

Required Date: 3/19/10 Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

I-install D3671-1 as per dwg D2807

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: 020

Memo

0.00

0.00

4510/23/24 (24)

counter
(x24)

PC 4/3/24 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56882

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March 12, 2010 10:01:02 AM

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Item Name: Door prop

Stop



Start Date: 3/12/10 Start Qty: 24.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/30

BS 10-3-29

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 12, 2010 10:01:01 AM

Page 1

Work Order ID: 56882

Parent Item: D2807-041

Parent Item Name: Door prop

Start Date: 3/12/10

Required Date: 3/19/10

Comments: IPP: D1107.11.12 ecn1019, replaces D280711 ECI verified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

6/15-164/50-115N
Purchased

No

130

Each

0.0000

24.0000

7

Gas Spring

D3671-1

Manufactured

No

110

Each

9.0000

24.0000

Placard

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

55650

9

9

C210/3/22

8/5/10/03/24
B56883 (15x)

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

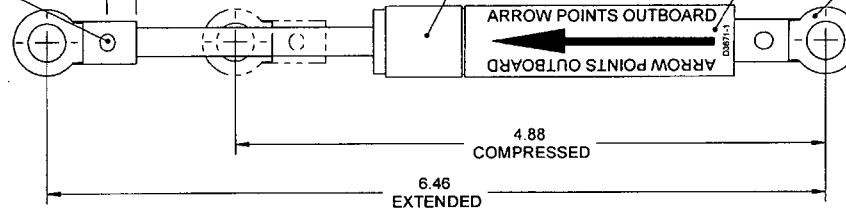
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH Ø0.375 TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

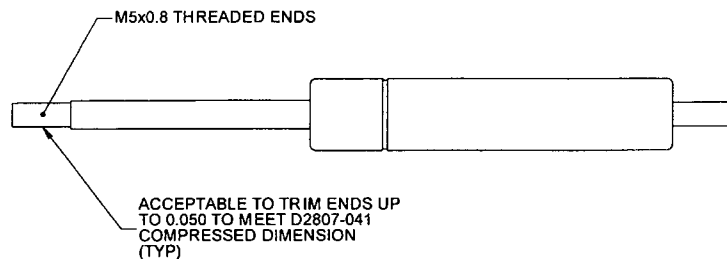
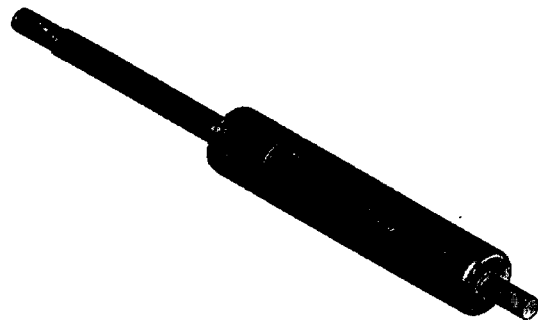
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

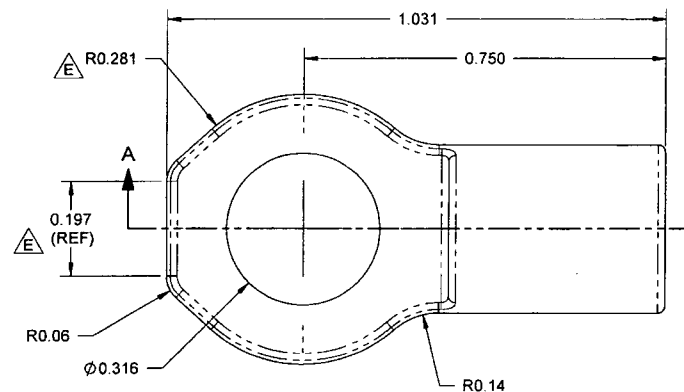
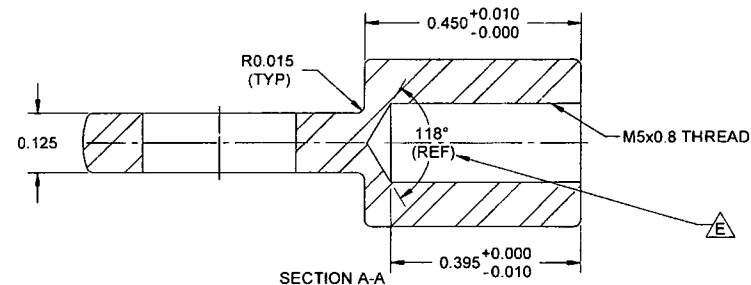
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

CL10/3/12
W10:56882

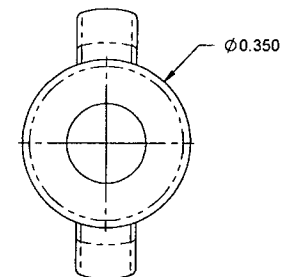
REV.	DESCRIPTION	BY	DATE
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
DESIGN	AW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2807 TITLE GAS SPRING <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AW		
CHECKED	JE		
MFG. APPR.	W.P.		
APPROVED	W.P.		
DE APPR.	W.P.	REV. E	SHEET 1 OF 3
DATE	07.12.28	SCALE	NTS



D2807-1 GAS SPRING
SCALE 1:1



D2807-3 LUG



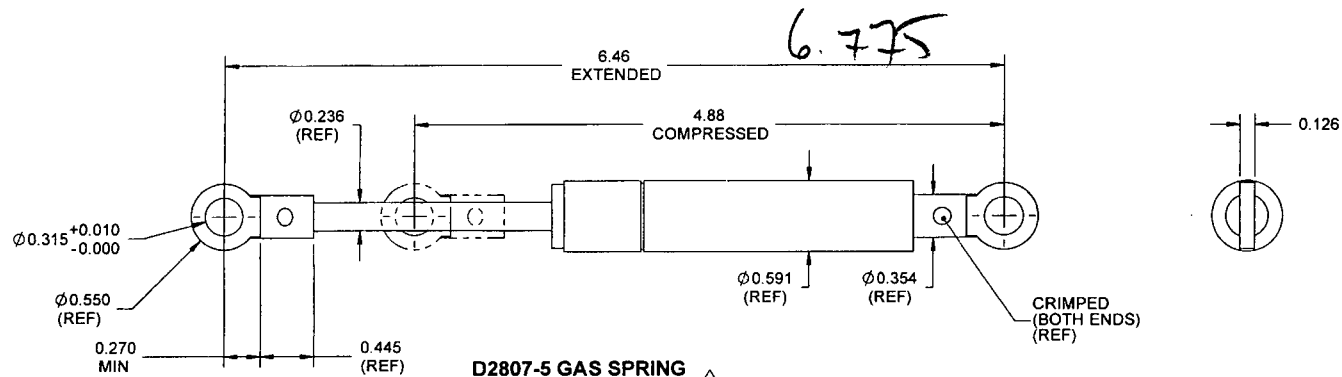
D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO. D2807	REV. E
CHECKED	JE	SHEET 2 OF 3	
MFG. APPR.	JE	TITLE GAS SPRING	SCALE 4:1
APPROVED	JE	DATE 07.12.28	
DE APPR.	JE	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR.	KE	SHEET 3 OF 3	
APPROVED	PH	TITLE GAS SPRING	SCALE 4:1
DE APPR.	PH	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO11504**

Purchase Order Date 3/12/10

PO Print Date 3/12/10

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

FAKED
6/10/30

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	3/18/10 Yes	24.00 Each	FedEx PI collect	\$63.9000	\$1,533.6

Special Inst:

AS PER DWG D2807 REV. E
B56882
LS TECHNOLOGIES P/N: 6/15-164/50-
115N

PO Total:

\$1,533.6

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 3/12/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

24 Units: D2807 - 6/15-164/50-115N Stainless Gas Spring

Country of Manufacture: Canada
Date of Manufacture : March 2010
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 11504
Invoice # 5880

8/10/03/18

L S Technologies Inc Canada

Nolan Fehr
Manager